

Work Order ID 113989

113989

Page 1

Friday, February 28, 2014 10:03:46 AM

Item ID: D4466-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Upper Door Assembly, RH
 Start Date: 2/28/2014 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 3/21/2014 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Mf Date: 14-2-28 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4466	D

100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									

110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	Transfer drill hole thru skin as per dwg (see note 10)								
	Dimple for c'sunk rivets.(see note 11-12)								
	Assemble as per dwg and install rivet wet using proseal (see note 8)								
	Seal gaps with proseal as per dwg (see note 9)								
	Proseal 890 B-2 Batch: <u>M130986</u>								

14/2/25 (1) 32
 1X 15/01/21 9-89
 DAS 36

14-7-31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Work Order ID 113989

113989

Page 2

Friday, February 28, 2014 10:03:46 AM

Item ID: D4466-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Door Assembly, RH
Start Date: 2/28/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/21/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00				1			EB
Quality Control									15-01-12
130	Identify as per dwg & Stock Location <u>G-A</u>	0.00							
130									
Packaging	Memo	0.00				1X			15/01/22
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									MIC 16-3-8

DAS
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Picklist Print

Page 1

Friday, February 28, 2014 10:03:45 AM

Work Order ID: 113989

113989

Parent Item: D4466-042

D4466-042

Parent Item Name: Upper Door Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:D 12.12.03 per dwg revC DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4474-3		Manufactured	No			100	Each	22.0000	6	6		2/28 32 9-89	
										**			

D4474-3

Splice Block

Location	Loc Qty	Loc Code
CA	22	
95312	12	
99109	10	

95312

D4496-042		Manufactured	No			100	Each	0.0000	1	1		DAS 32 9-89	
										**			

D4496-042

Upper Door Channel Assembly, RH

D4499-2		Manufactured	No			100	Each	0.0000	1	1		DAS 32 9-89	
										**			

D4499-2

Upper Door Channel, RH

D4500-2		Manufactured	No			100	Each	2.0000	1	1			
										**			

D4500-2

Bell Door Header, RH

Location	Loc Qty	Loc Code
CA	2	
95469	2	

117600 MF 14-5-5

D4501-042		Manufactured	No			100	Each	0.0000	1	1		DAS 32 9-89	
										**			

D4501-042

Upper Door Corner Assembly, RH

D4503-1		Manufactured	No			100	Each	0.0000	1	1			
										**			

D4503-1

Upper Door Skin

114012 MF 14-05-01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Picklist Print

Friday, February 28, 2014 10:03:45 AM

Page 2

Work Order ID: 113989

113989

Parent Item: D4466-042

D4466-042

Parent Item Name: Upper Door Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

D4570-4 Manufactured No

100

Each

0.0000

1

1

D4570-4

Bracket, RH

MS20426AD4-3 DAS

Purchased No

100

Each

4,831.000

39

39

MS20426AD4-3

Rivet

Location

Loc Qty

Loc Code

GA

1831

113064

1831

ST334

3000

m125807

3000

MS20426AD3-4

Purchased No

100

Each

9,927.000

20

20

MS20426AD3-4

RIVET

Location

Loc Qty

Loc Code

MF4

561

125578

561

ST334

4000

m127432

4000

ST509

5366

125578

5366

MS20426AD3-5

Purchased No

100

Each

7,074.000

16

16

MS20426AD3-5

Rivet

Location

Loc Qty

Loc Code

GA

4832

4533

4832

ST334

2242

4444

2242

**

**

**

**

DAS
32
9-89

DAS
32
9-89

DAS
32
9-89

114013 MF 14-5-5

713064

M125445
(392)

125378

4444

14/4/25 (1)

Friday, February 28, 2014 10:03:45 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design ☐											
Doc/Data ☐											
Equip/Tooling ☐											
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Material ☐											
Operator ☐											
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Supplier ☐											
Training ☐											
Transport ☐											
Unapproved ☐											

FAULT CATEGORY			
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____

Picklist Print

Friday, February 28, 2014 10:03:45 AM

Page 3

Work Order ID: 113989

113989

Parent Item: D4466-042

D4466-042

Parent Item Name: Upper Door Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-5 Purchased No

100 Each 1,592.000 26 26

DAS
32
9-89

MS20426AD4-5

**

RIVET

Location

Loc Qty

Loc Code

ST334

1592

6874

592

m125807

1000

6874

MS20470AD4-3 Purchased No

100 Each 5,399.000 42 42

DAS
32
9-89

MS20470AD4-3

**

Rivet - Universal Head

Location

Loc Qty

Loc Code

GA

1516

1642

73

2193

1443

ST335

3883

2193

3883

2193

MS20470AD4-4 Purchased No

100 Each 236.0000 6 6

DAS
32
9-89

MS20470AD4-4

**

Rivet, Universal Head

Location

Loc Qty

Loc Code

GA

180

121652

180

ST336

56

118614

56

118614

15/01/22
M1130224
420

14/4/25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Picklist Print

Page 4

Friday, February 28, 2014 10:03:45 AM

Work Order ID: 113989

113989

Parent Item: D4466-042

D4466-042

Parent Item Name: Upper Door Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-5

Purchased

No

100

Each

1,340.000

53

53

MS20470AD4-5

RIVET, UNIVERSAL HEAD

**

DAS
32
9-89

Location

Loc Qty

Loc Code

GA

335

m126926

335

ST336

1005

m126926

1005

m126926

MS20470AD4-7

Purchased

No

100

Each

5,673.000

24

24

MS20470AD4-7

Rivet, Universal Head

**

DAS
32
9-89

Location

Loc Qty

Loc Code

ST336

2980

123525

1680

m128228

1300

ST509

2693

124231

2693

m123525

MS21059L3

Purchased

No

100

Each

283.0000

8

8

MS21059L3

Nut Plate

**

m12770

14/4/2014

m128635

Location

Loc Qty

Loc Code

ST315

277

M127916

77

M128300

200

ST316

6

M127743

6

Friday, February 28, 2014 10:03:46 AM

Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 113989

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Parent Item: D4466-042

D4466-042

Parent Item Name: Upper Door Assembly, RH

Start Date: 2/28/2014

Required Date: 3/21/2014

Start Qty: 1.00

Required Qty: 1.00

MS21059L3K

Purchased

No

100

Each

879.0000

10

10

DAS
32
9-89

MS21059L 3K

**

14/4/25 (1)

Nutplate

Location

Loc Qty

Loc Code

GA

257

m127635

257

ST316

622

m127703

622

11/27/03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

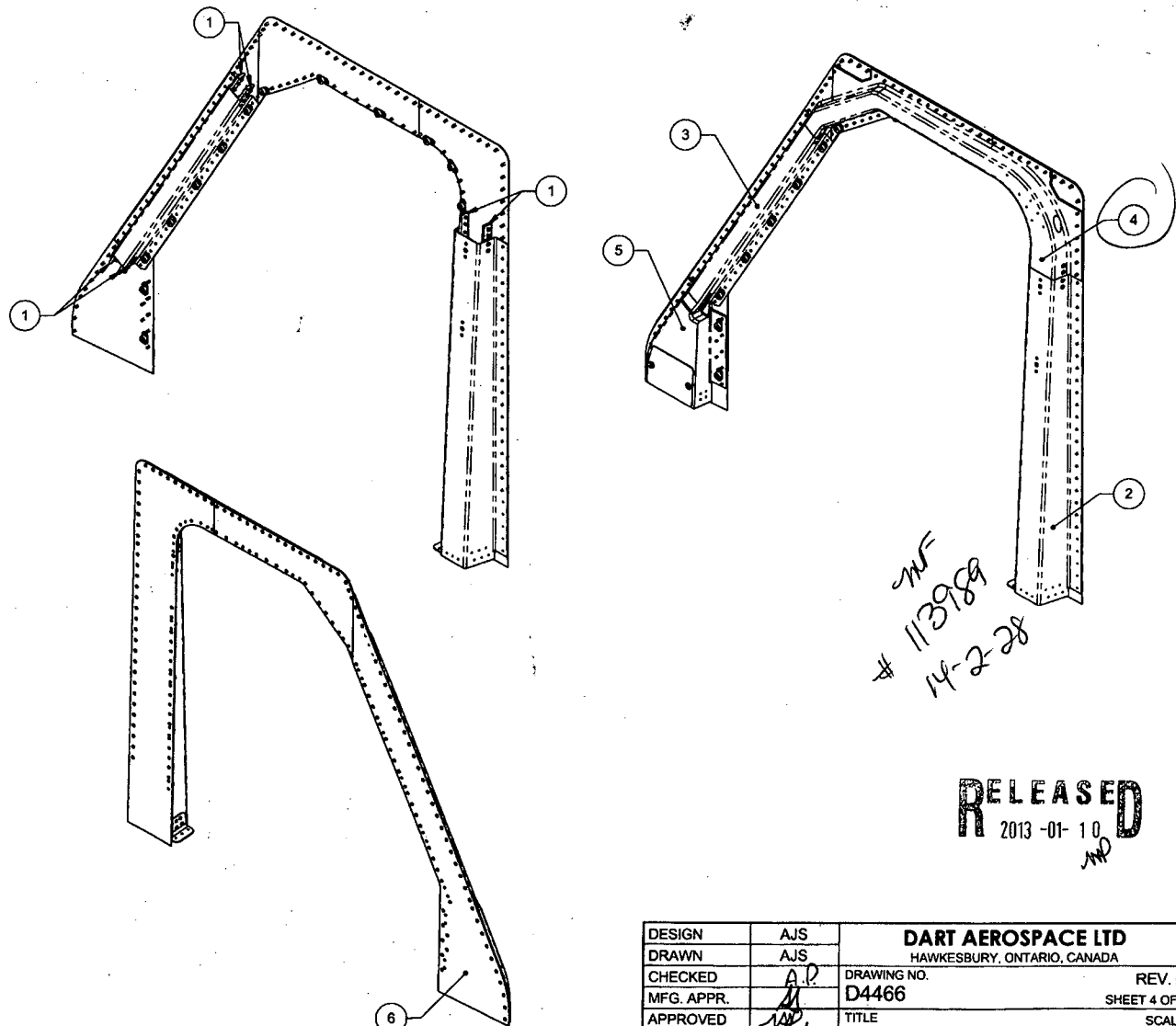
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☒									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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ITEM	QTY -042	P/N	DESCRIPTION
	X	D4466-042	UPPER DOOR ASSY (RH)
1	6	D4474-3	SPLICE BLOCK
2	1	D4496-042	UPPER DOOR CHANNEL ASSY (RH)
3	1	D4499-2	UPPER DOOR CHANNEL (RH)
4	1	D4500-2	BELL DOOR HEADER (RH)
5	1	D4501-042	UPPER DOOR CORNER ASSY (RH)
6	1	D4503-1	UPPER DOOR SKIN
7	1	D4570-4	BRACKET (RH)
8	16	MS20426AD3-5	RIVET, CSK
9	20	MS20426AD3-4	RIVET, CSK
10	39	MS20426AD4-3	RIVET, CSK
11	26	MS20426AD4-5	RIVET, CSK
12	42	MS20470AD4-3	RIVET, PAN HEAD
13	6	MS20470AD4-4	RIVET, PAN HEAD
14	53	MS20470AD4-5	RIVET, PAN HEAD
15	24	MS20470AD4-7	RIVET, PAN HEAD
16	8	MS21059L3	NUTPLATE
17	10	MS21059L3K	NUTPLATE



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.73 lbs
- 8) INSTALL ALL RIVETS WET USING PROSEAL 890 B-2 (PRC)
- 9) SEAL ALL GAPS ON MATING PARTS USING PROSEAL 890 B-2 (PRC)
- 10) ALL RIVET HOLES TO BE TRANSFER DRILLED THRU SKIN (ITEM 6):
FOR Ø0.125 RIVETS DRILL Ø0.129
FOR Ø0.094 RIVETS DRILL Ø0.098
- 11) DIMPLE FOR COUNTERSUNK RIVETS:
FOR Ø0.125 RIVETS DIMPLE Ø0.225 X 100°
FOR Ø0.094 RIVETS DIMPLE Ø0.179 X 100°
- 12) THESE RIVETS OMITTED TO ALLOW ACCESS TO THE UNDERLYING STRUCTURE, INSTALL AT NEXT ASSEMBLY.

D4466-042 UPPER DOOR ASSY (RH)

RELEASED
2013-01-10
MD

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO. D4466	REV. D
MFG. APPR.	A.P.	SHEET 4 OF 6	
APPROVED	A.P.	TITLE UPPER DOOR ASSY	SCALE NTS
DE APPR.	A.P.	DATE 12.12.03	

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

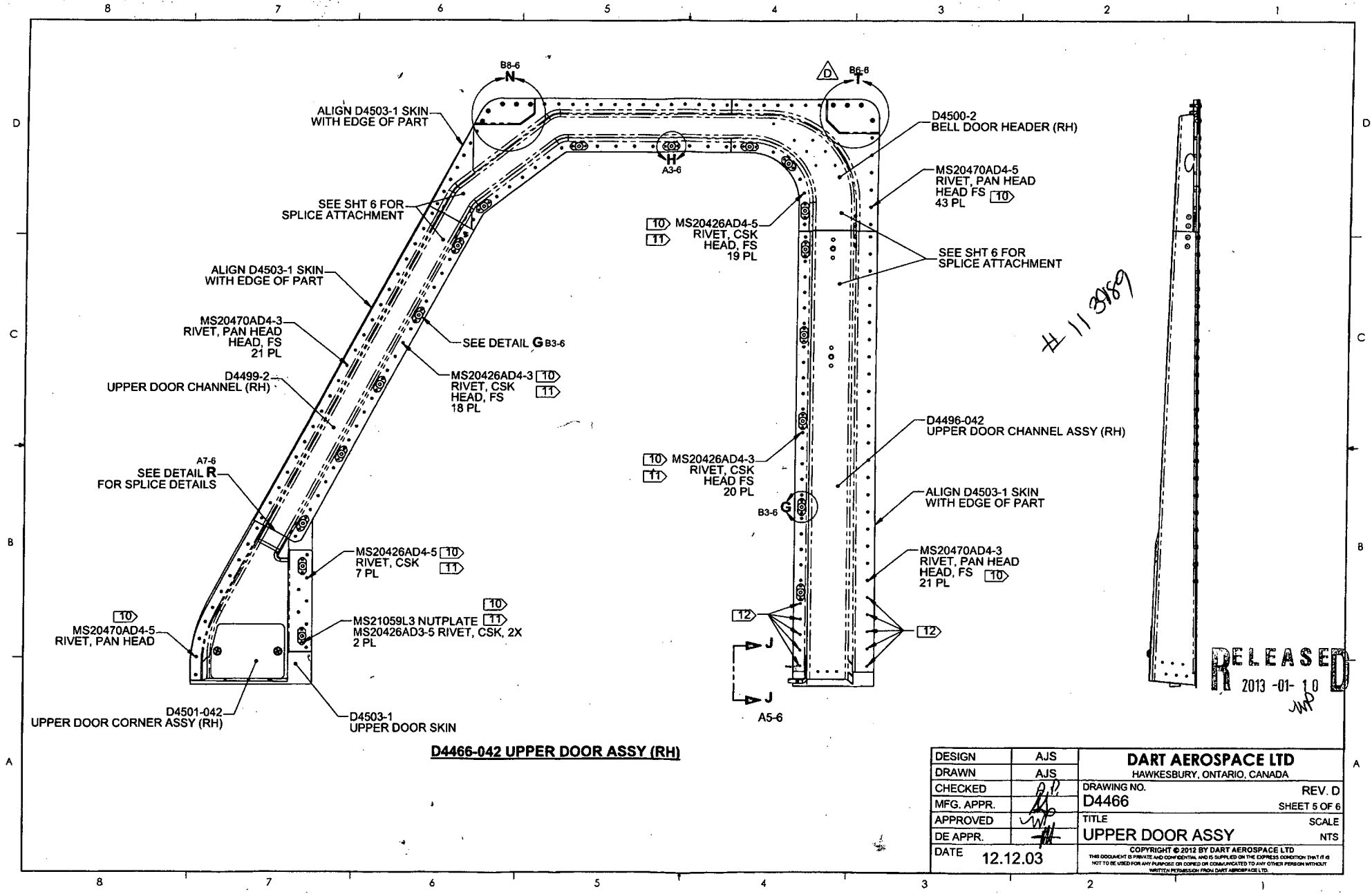
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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D4466-042 UPPER DOOR ASSY (RH)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.		D4466	SHEET 5 OF 6
APPROVED	W	TITLE	SCALE
DE APPR.		UPPER DOOR ASSY	NTS
DATE	12.12.03	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

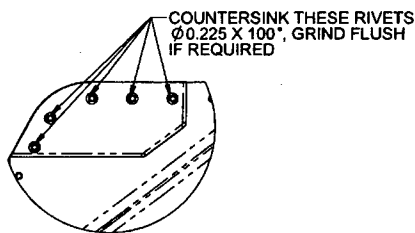
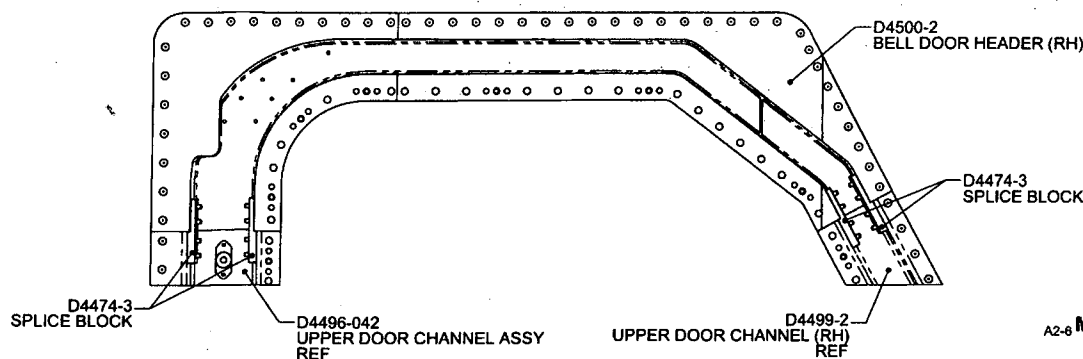
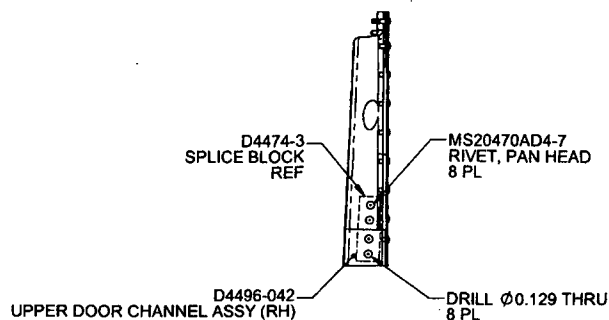
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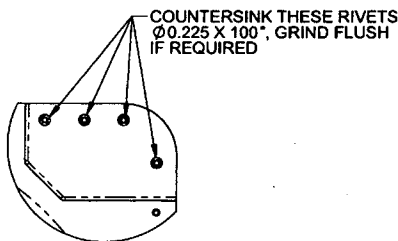
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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

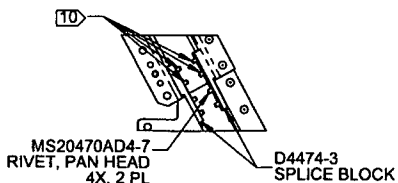
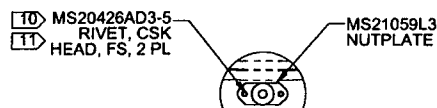
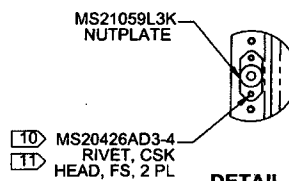
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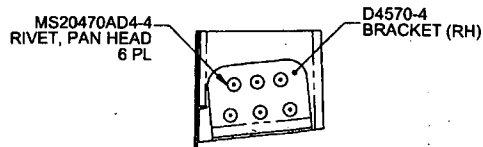
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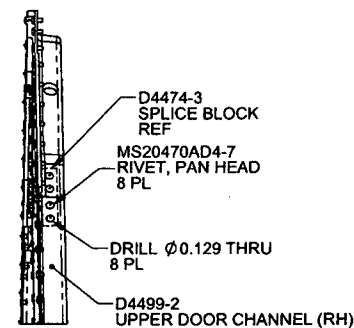
DETAIL T D3-5
(SCALE 2X)



DETAIL R B7-5



SECTION J-J A4-5
(SCALE 2X)



SECTION M-M C1-6

RELEASED
R 2013-01-10

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO. D4466	REV. D
MFG. APPR.			SHEET 6 OF 6
APPROVED		TITLE UPPER DOOR ASSY	SCALE
DE APPR.			NTS
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